



Dart Aerospace Ltd.
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D5046-7
Job Sheet 186636



Part No: D5046-7

Job Qty: 4 ea

Part Name: Co-Pilot Collective Head



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No:

Due Date: 11/29/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B SHEETS 4,11,12 IPP REV. A NEW ISSUE JFS 14/04/14 VERIFIED BY: DD IPP REV. B MAT'L SIZE HAS CHANGED AS PER REV.B JFS 15/09/23 VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/29/18	11/29/18	0.00	0.00	Start Up Machining-3		<i>[Signature]</i>
100	Bandsaw	4 pcs	11/29/18	11/29/18	0.00	0.01	Bandsaw1		<i>[Signature]</i>
110	CNC Vertical Machining	4 pcs	11/29/18	11/29/18	0.00	15.70	HAAS1-5		<i>[Signature]</i>
120	QC	4 pcs	11/29/18	11/29/18	0.00	0.00	QC2 Machining-3		<i>[Signature]</i>
130	Mill Conv	4 pcs	11/29/18	11/29/18	0.00	0.55	Conv Mill 1		<i>[Signature]</i>
140	QC	4 pcs	11/29/18	11/29/18	0.00	0.00	QC2 Machining-3		<i>[Signature]</i>
150	QC	4 pcs	11/29/18	11/29/18	0.00	0.00	QC8 Machining-3		<i>[Signature]</i>
160	Packaging	4 pcs	11/29/18	11/29/18	0.00	0.00	Packaging3-2		<i>[Signature]</i>
170	QC21-SA	4 Ea	11/29/18	11/29/18	0.00	0.00	QC21		<i>[Signature]</i>

Part Op 100 - CUT BLANK AT 5.500"

Descriptions: 110 - MACHINE AS PER DWG & FOLIO FB296/ D5046-7 FOLIO REV: _____ DWG REV: _____ ***DO NOT BUFF OR POLISH PART*** DEBURR

130 - DRILL REMAINING 2 HOLES AS PER DWG. DWG REV: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B06.000X02.000	Aluminum Bar 6.00 X 2.00	1.8360 ft (.459 ea)	90-Start up Operation	4x FM B6801

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B06.000X02.000	2	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S129606



Part: D5046-7

Job No: 186636

Serial No/Batch: S129606

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 11/20/18

DART AEROSPACE LTD		Work Order: 186636 185328
Description: CO-Pilot collective Head		Part Number: D5046-7
Inspection Dwg:	Rev: B	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.150 X 0.6000	+0.005/-0.001 X ± 0.010	0.150 X 0.602	✓		Kt-05	verm
0.350	+/- 0.010	0.352	✓		" "	" "
3.350	+/- 0.010	3.350	✓		H-G	31006
0.300	+/- 0.010	0.300	✓		" "	" "
2.808	+/- 0.005	2.808	✓		" "	" "
1.892	+/- 0.005	1.892	✓		" "	" "
1.214	+/- 0.005	1.214	✓		" "	" "
2.136	+/- 0.005	2.136	✓		" "	" "
0.25	+/- 0.030	0.250	✓		Kt-01	micrometre
R0.13	+/- 0.030	0.130	✓		—	R-G
1.66	+/- 0.030	1.662	✓		Kt-05	verm.
0.830	+/- 0.010	0.830	✓		" "	" "
0.375	+/- 0.005	0.375	✓		H-G	31006
Ø 0.136	+0.005/-0.001	0.136	✓		Kt-05	verm
Ø 0.484	+0.005/-0.001	0.484	✓		" "	" "
1.450	+/- 0.010	1.448	✓		" "	" "
0.830	+/- 0.010	0.830	✓		Kt-05	verm.
Ø 0.160	+0.005/-0.001	0.160	✓		" "	" "
Ø 0.500	+0.006/-0.001	0.502	✓		" "	" "
Ø 0.860 X 0.150 DP	+0.010/-0.001	0.862 X 0.150	✓		" "	" "
0.375	+/- 0.005	0.375	✓		H-G	31006
2.460	+/- 0.010	2.460	✓		Kt-05	verm
0.254	+0.005/-0.000	0.256	✓		" "	" "
0.200	+/- 0.030	0.200	✓		" "	" "
0.50	+/- 0.030	0.500	✓		" "	" "
5.30	+/- 0.030	5.300	✓		" "	" "
4.00	+/- 0.030	4.000	✓		" "	" "
1.660	+/- 0.010	1.660	✓		" "	" "
Ø 0.625	+0.005/-0.000	0.625	✓		" "	" "
Ø 0.502	+0.005/-0.001	0.504	✓		" "	" "
0.830	+/- 0.030	0.830	✓		" "	" "

Measured by: Kt / 18/11/21	Checked by: [Signature]	QC Inspector:
Date: 2018/11/19	Date: 18/11/21	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

